

Work Order ID 52893

October 19, 2009 10:37:54 AM



Page 1

Item ID: D2512
Revision ID: E
Item Name: Basket Lid 205/350

Accept



Setup Start



Stop



Start Date: 10/19/09 Start Qty: 1.00
Required Date: 10/27/09 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *RL* Date: *09-10-19*
QC: Date:

Tooling:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2512	Rev E

P/O →

100 Weld per dwg A/R S.S. rod Batch: *M109213* 0.00
Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512
2-Cut (4) D2236 From D3166-3
3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305
4-Weld as per Dwg D2512 using Welding Jig DT 9436
Deburr as required
INSTALL D2012-117 CLEVIS ONLY ON D130-701-04

PD

09.11.02
09.0

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

09 11 03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09-11-18	100	Add step to shear mesh to size, not Not mentioned in Memo. See NCR below. perm change				09-11-18	09-11-18

Part No: D2512 PAR #: _____ Fault Category: Large Def NCR: (Yes) No DQA: / Date: 09-11-18
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: / Date: 09-11-18

NCR: <u>52893</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/10/30	100	During welding Found that mesh for lid was cut/sheared crossed from in with from one end to the other.	Resumr	Scrap and Destroy mesh. → was all ready tracked in place when problem was found - Replace M ^o 112311	SAD 09-10-02 PD 09-11-02	S 09/10/30	Resumr	S 09/10/30
		R.C. employee who stepped cut the mesh out at cracks. Employee went off using his L.O.A. (SAD)	Resumr	Not			Resumr	S 09/10/30

NOTE: Date & initial all entries

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Item ID: D2512

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Required Date: 10/27/09 Req'd Qty: 1.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

>> S o r t u b o r

(X) f

QC

Memo

0.00

Quality Control

130

* pressure-wash
White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

> H l 09/11/09

(X) 0

Powdercoat

Memo

0.00

Powder Coating

I- Plug holes in D2581 and in D2327-1 bushing prior to Powdercoat

1ST COAT:

START TIME: 2:15pm

OVEN TEMPERATURE: 400°F

FINISH TIME: 2:45pm

2ND COAT:

START TIME: 3:10pm

OVEN TEMPERATURE: 400°F

FINISH TIME: 3:40pm

Page 3

Accept

**Setup Start**

Stop

**Cust Item ID:**

Customer:

Reference:

Run Start

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

[illegible]

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Item ID: D2512

Accept



Setup Start



Revision ID: E

Stop



Item Name: Basket Lid 205/350

Start Date: 10/19/09 Start Qty: 1.00



Cust Item ID:

Required Date: 10/27/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/10 *[Signature]*

YMF
09-11-10

Picklist Print

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4

Work Order ID: 52893

Parent Item: D2512RevE

Parent Item Name: Basket Lid 205/350


Start Date: 10/19/09

Required Date: 10/27/09

Comments:

Start Qty: 1.00


Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2012-117RevC		Manufactured	No			100	Each	28.0000	2.0000			
												
Clevis												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	28	
31101	2	
52498	26	

PD 09.10.29

ONLY APPLICABLE ON DI30-701-CH

D2232-1RevC		Manufactured	No			100	Each	30.0000	2.0000			
												
Basket Hinge												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2	
48230	2	
Main Warehouse		
WA	28	
50896	8	
51105	20	

PD 09.10.29

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Work Order ID: 52893

Parent Item: D2512RevE

Parent Item Name: Basket Lid 205/350


Comments:

Start Date: 10/19/09

Required Date: 10/27/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2327-1RevD		Manufactured	No			100	Each	45.0000	2.0000			
												
Spacer Bushing												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

45

51331

20

52832

25

PD 09.11.02

D2506RevF

Manufactured No

100

Each

6.0000

1.0000



Label Plate

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

2

44275

1

51135

1

Main Warehouse

WA

4

51303

4

52834

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Work Order ID: 52893

Parent Item: D2512RevE

Parent Item Name: Basket Lid 205/350



Comments:

Start Date: 10/19/09

Required Date: 10/27/09



Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2581RevA1		Manufactured	No			100	Each	74.0000	2.0000			
												
Mounting Bracket												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	13	
46086	2	
48428	1	
51120	10	
Main Warehouse		
WA	61	
50872	12	
51745	49	

PD 09.10.29

D3166-3RevA1		Manufactured	No			100	Each	13.6210	1.0000			
												
Basket Hoop												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
WA	13.621	
50033	0.0527	
50618	1.5683	
51249	6	
52058	6	

PD 09.10.28

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Picklist Print

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Work Order ID: 52893

Parent Item: D2512RevE

Parent Item Name: Basket Lid 205/350

Comments:

Start Date: 10/19/09

Required Date: 10/27/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304EX0.75-16F		Purchased	No			100	sf	201.0648	18.9474			
Expanded Metal Flat SS												



SAD 09-10-22

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	201.0648065	
110134	6.7	
111630	9.15	
111956	0.000017	
112147	8.29428947	
112311	28.9205	
112707	148	

18.9474

M304TS0.750W.065

Purchased

No

100

f

561.0601

45.8741



304 SQ Tube .75x.75x.065W

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
WA	561.0601	
112398	561.0601	

D 09.10.23

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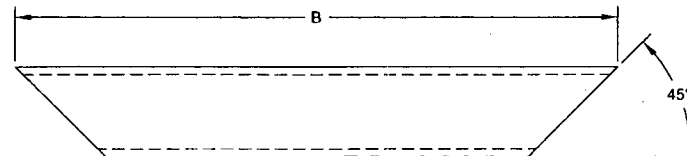
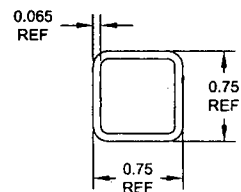
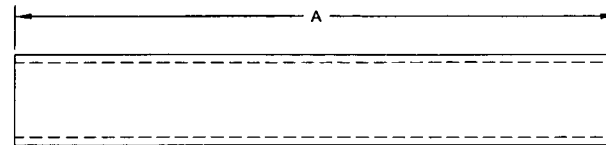
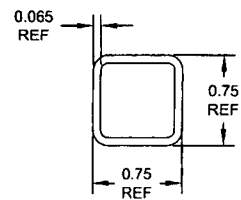
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PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET

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WORK ORDER
NO. 52993
PL 02-10-19



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08-08-21-11

E

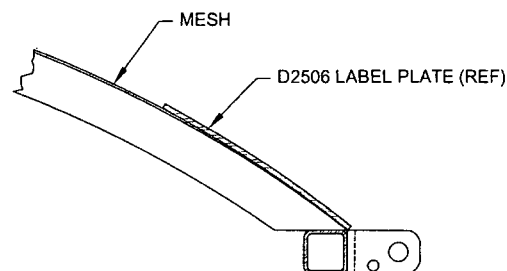
D2512-1/-3/-5/-7 NOTES:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

E	INCORPORATED D1 & D2 MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2512 REV. E SHEET 1 OF 4 TITLE BASKET LID ASSEMBLY (350/212) SCALE NTS	
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.06.17	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE FIRM'S CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY DISSEMINATION TO ANY OTHER PERSON OR ENTITY WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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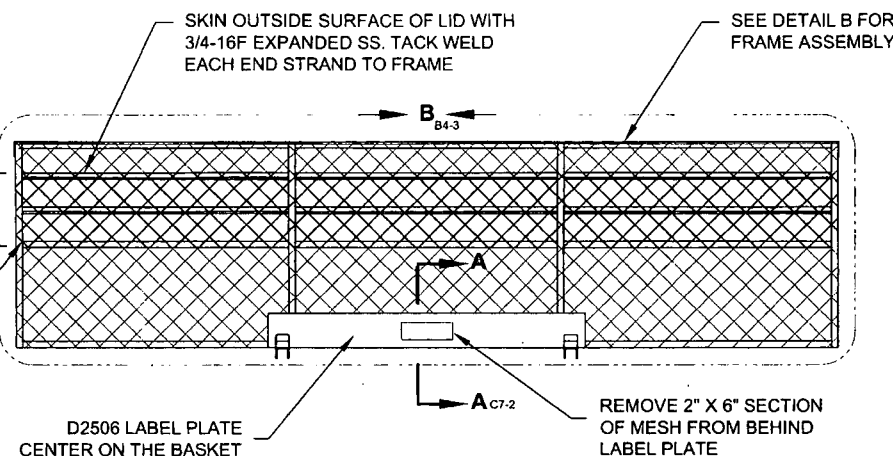
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WORK ORDER NO. 52993



SECTION A-A B3-2
(ROTATED 90° CCW)

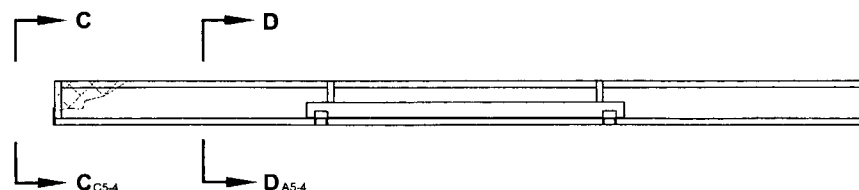
FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT.

TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKIDDED



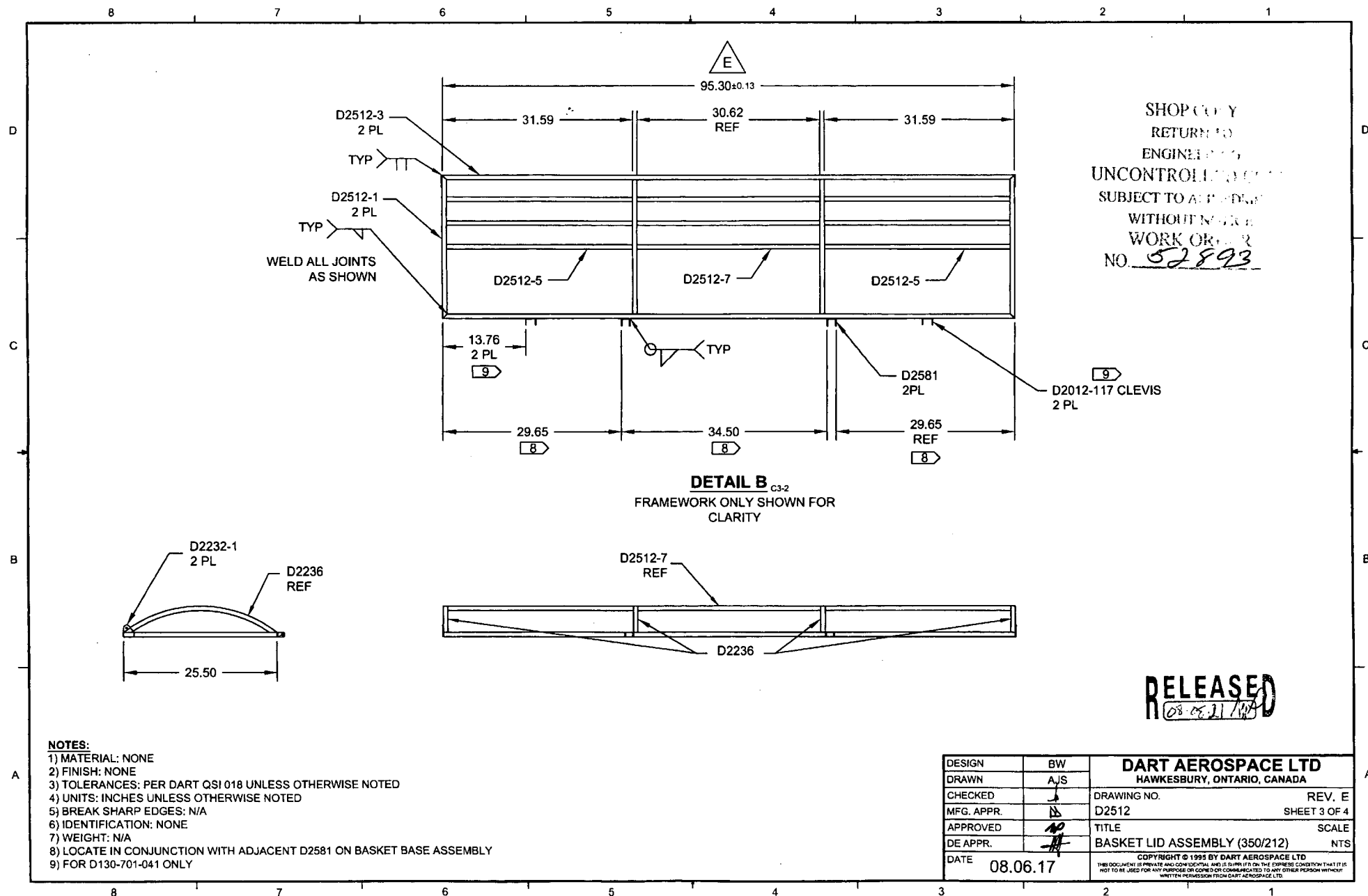
D2512 BASKET LID ASSEMBLY NOTES:

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004

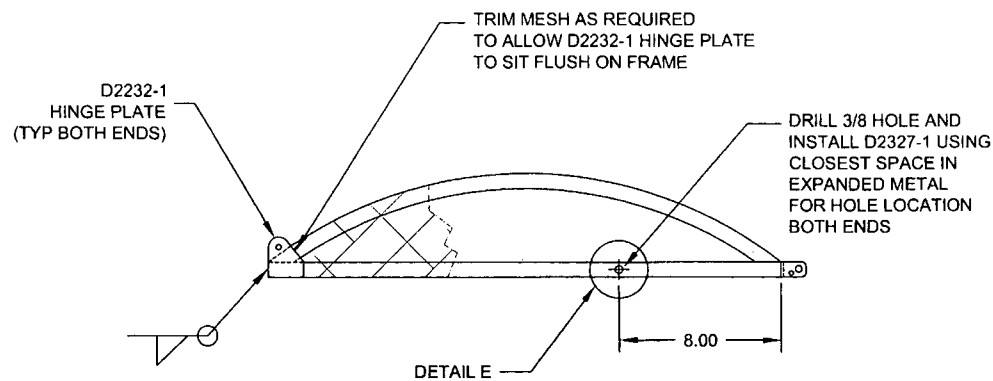


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08.06.17

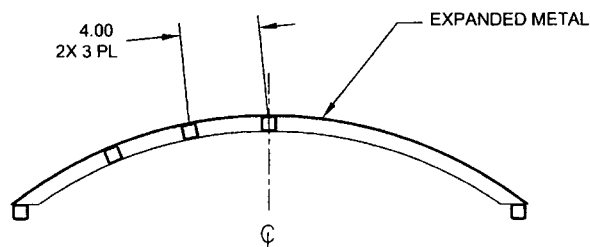
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATIONS TO ANY OTHER PERSON OR ENTITY WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



8 7 6 5 4 3 2 1

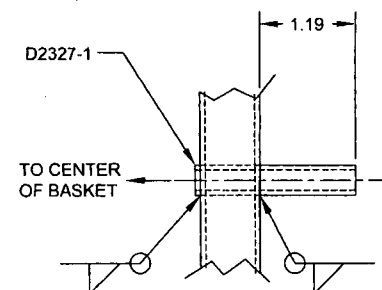


VIEW C-C SIMILAR BOTH END RIBS A5-2



SECTION D-D SAME BOTH CENTER RIBS A4-2

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52893



DETAIL E C6-4

RELEASED
08.06.17

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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8 7 6 5 4 3 2 1